

Date: Tuesday, 12/12/2006 7:39:07 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING PLATE
Job Number	: 29869		
Estimate Number	: 11071		
P.O. Number	: <i>pm</i>	Part Number	: D2957
This Issue	: 12/12/2006 S.O. No. : <i>nm</i>	Drawing Number	: D2957 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>nm</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	: <i>pm</i>
Written By	:	Due Date	: 12/22/2006
Checked & Approved By	: <i>J.F. 06/12/13</i>	Qty:	18
Comment	: Est: C 00.08.09 New dwg rev B (mpp 2078) EC	Um:	12
		Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X01250	6061-T6 Bar .50" x 1.25"
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Comment: Qty.: 0.9188 f(s)/Unit Total : 11.0250 f(s)

6061-T6 Bar .50" x 1.25"

Material: 6061-T6 bar 1.25" x 0.50"

Batch: *M100742*

J.F. 06/12/13

(20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 10.500" long

1 blank makes 5 parts

J.F. 06/12/13

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA042

Tumble & Deburr

J.F. 06/12/13

18

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/12/13

18

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

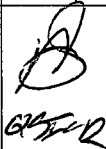
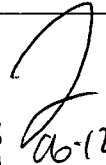
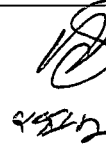
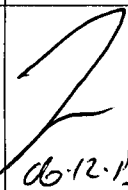
J.G. 06/12/13

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/15

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/13	3	2 pieces are scrap. The dimension, 250 is too thin.		Scrap, no replace over on Qty.	J.F. 06/12/13	 06-12-13	 06-12-13	 06-12-13

NOTE: Date & initial all entries

Date: Tuesday, 12/12/2006 7:39:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING PLATE

Job Number: 29869

Part Number: D2957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: ~~INSPECT CHEMICAL CONVERSION COAT~~

Inspect work

Feb 12-14

(170)

(8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W.S.

Feb 12-14

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Feb 12/13

(18)

Job Completion



Feb 12-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-12-14	6-0	Remove Inspect Alodine, → inspect work to step. perm. change <i>[Signature]</i>					<i>[Signature]</i> 06-12-14	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29869
Description: Mounting Plate		Part Number:	D2957
Inspection Dwg: D2957	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	.250"	✓			
0.068	+/-0.010	.068"	✓			
Ø0.323	+/-0.010	.326"	✓			
0.250	+/-0.010	.246"	✓			
1.06	+/-0.030	1.066"	✓			
0.875	+/-0.010	.876"	✓			
0.449	+/-0.010	.451"	✓			
R0.12	+/-0.030	R0.12	✓			
1.85	+/-0.030	1.85"	✓			
0.250	+/-0.010	.243"	✓			
0.19	+/-0.030	.190"	✓			
0.125	+/-0.010	.127"	✓			
Ø.191"	+0.005 -0.001	Ø.191	✓			

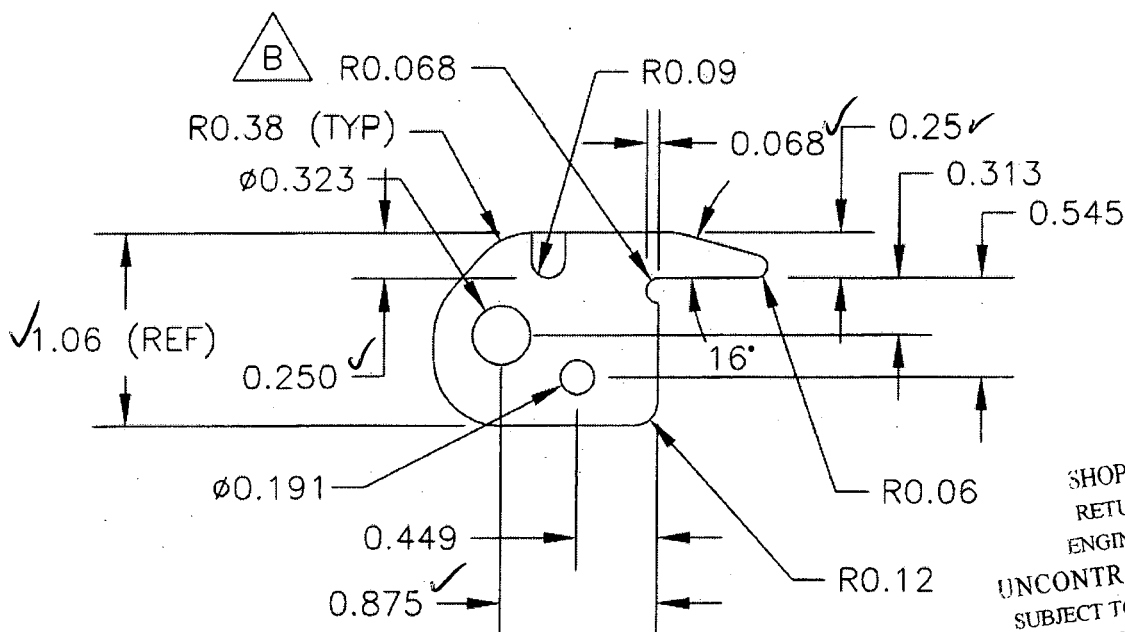
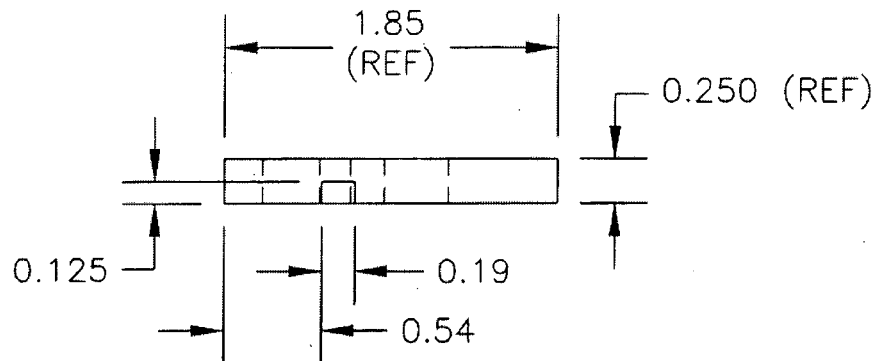
Measured by: J.F.	Audited by: SD	Prototype Approval:	N/A
Date: 06/12/13	Date: 06.12.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	HF



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2957	REV. B SHEET 1 OF 1
DATE 00.07.06		TITLE MOUNTING PLATE	SCALE 1:1
A	00.01.20	NEW ISSUE	
B	00.07.06	MODIFY CORNER DETAIL	

RELEASED
00.07.10 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29869

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR
QQ-A-250/11) 0.250 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

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